

Work Order ID 139853

139853

December 10, 2015 10:29:52 AM

Page 1

Item ID: D022-661-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R22 Bearpaws
 Start Date: 12/10/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/23/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: 54 Date: 20151210 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3076	Rev A1

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPd022-661-011 CHG002									

2 **DAS 28 9-89** **MAR 07 2016**

110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

2x **DAS 26 9-89** **DEC 14 2015**

120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging Identify and pack for shipping as per PPP D022-661-011									

2 **DAS 28 9-89** **MAR 07 2016**

Location: fg014

Work Order ID 139853***139853***

Page 2

Item ID: D022-661-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R22 Bearpaws

Start Date: 12/10/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS

MAR 07 2016

MCS

MAR 07 2016

Picklist Print

December 10, 2015 10:29:56 AM

Page 1

Work Order ID: 139853

139853

Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 12/10/2015

Required Date: 12/23/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2182B		Manufactured	No			110	f	583.6313	0.93	1.86			
--------	--	--------------	----	--	--	-----	---	----------	------	------	--	--	--

2 ***D2182B*** 0.28
Rubber Cushion - Black (\$Per Foot)

**

DAS
26
9-89

DAS
28
9-89
1/1 x 2
par Kit.

Location	Loc Qty	Loc Code
ST411	583.6313	
130427	233.6313	
135093	350	

1.86

D2274		Manufactured	No			110	Each	65.0000	8	16			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

2 ***D2274***
Radius Block

**

DAS
26
9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	53	
136201	53	

16

D2529		Manufactured	No			110	Each	363.0000	8	16			
-------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

2 ***D2529***
Washer

**

DAS
26
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST008	363	
137534	363	

16

D2870		Manufactured	No			110	Each	124.0000	2	4			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

2 ***D2870***
Clamp

**

DAS
26
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
Mezz	124	
16244	31	
26941	93	

4

DEC 22 2015

Picklist Print

December 10, 2015 10:29:57 AM

Page 2

Work Order ID: 139853

139853

Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 12/10/2015

Required Date: 12/23/2015

Start Qty: 2.00

Required Qty: 2.00

D2871 Manufactured No 110 Each 152.0000 2 4

DAS
26
9-89
27
9-89

2 ***D2871***
Clamp

DAS
28
9-89

Location	Loc Qty	Loc Code
Mezz	152	
	48	
	104	
	16245	
	16838	

DEC 22 2015

D3076-1 Manufactured No 110 Each 2.0000 2 4

DAS
26
9-89
27
9-89

2 ***D3076-1***
R22 Bearpaw

DAS
28
9-89

Location	Loc Qty	Loc Code
ST454	2	
	2	
	135045	

42

1401432

DAS
26
9-89
27
9-89

AN4-13A Purchased No 110 Each 290.0000 8

DAS
26
9-89
27
9-89

2 ***AN4-13A***
Bolt

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	20	
	20	
122808	20	
ST344	270	
	270	
m133769	270	

24
16

m133769

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 8

DAS
26
9-89
27
9-89

2 ***AN960JD416***
Washer

DAS
28
9-89

16

m133316

DEC 17 2015

Picklist Print

December 10, 2015 10:29:57 AM

Page 3

Work Order ID: 139853

139853

Parent Item: D022-661-011

D022-661-011

Parent Item Name: R22 Bearpaws

Start Date: 12/10/2015

Required Date: 12/23/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

3,645.000

8

16

MS21042L 4

Locknut

DEC 14 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

49

m127813

49

ST260a

138

m130799

56

m131803

6

m132262

76

ST303

3287

m133363

287

m133769

3000

ST305

169

m128300

8

m130388

7

m130922

97

m132123

56

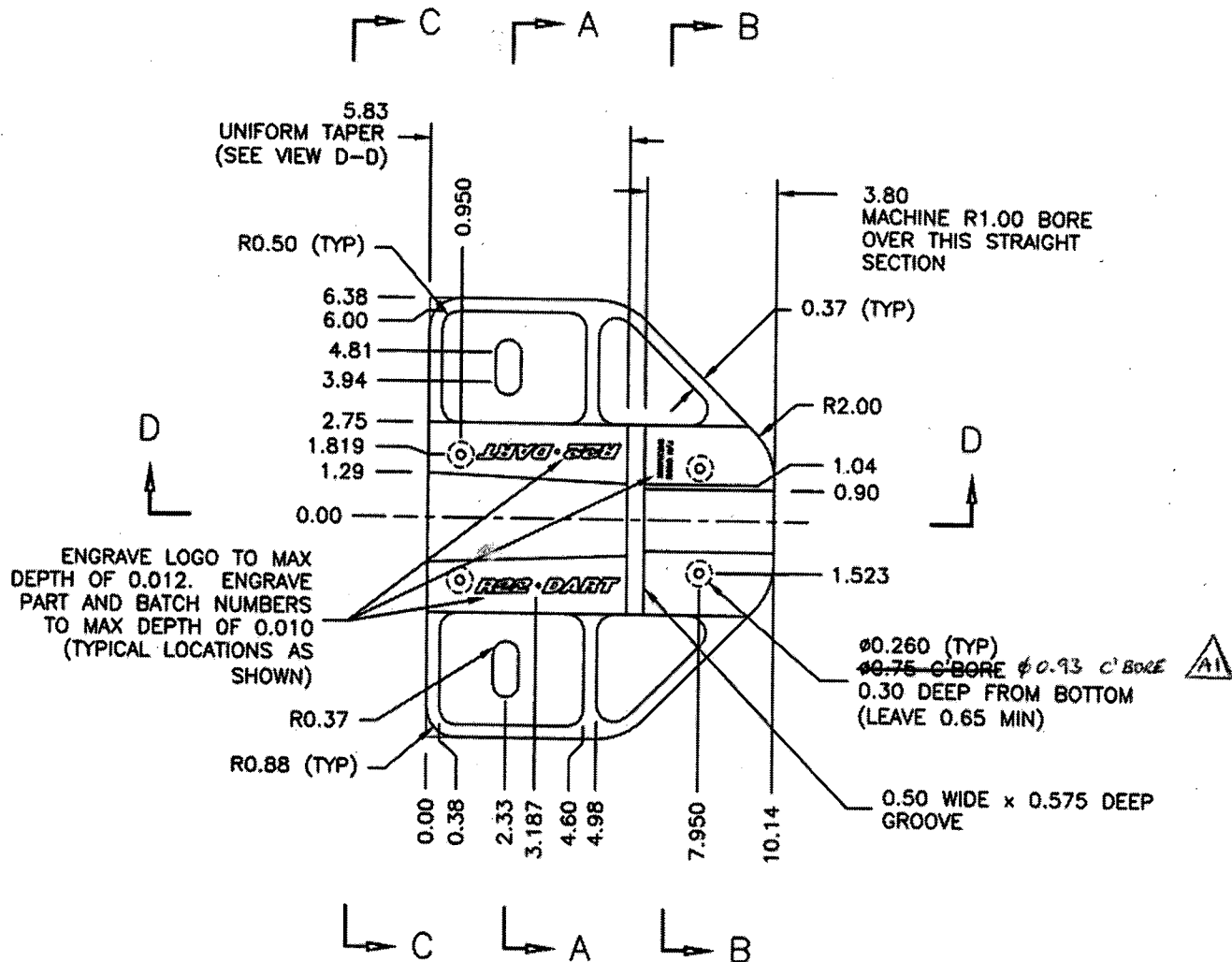
m133316

1



DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A SHEET 1 OF 2
DATE 02.01.08		TITLE R22 BEARPAW	SCALE 1:5
A	02.01.08	NEW ISSUE	
AI	03.01.06	$\phi 0.93$ WAS $\phi 0.75$	

RELEASED
02.01.10



D3076-1 BEARPAW (FLAT PATTERN)

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

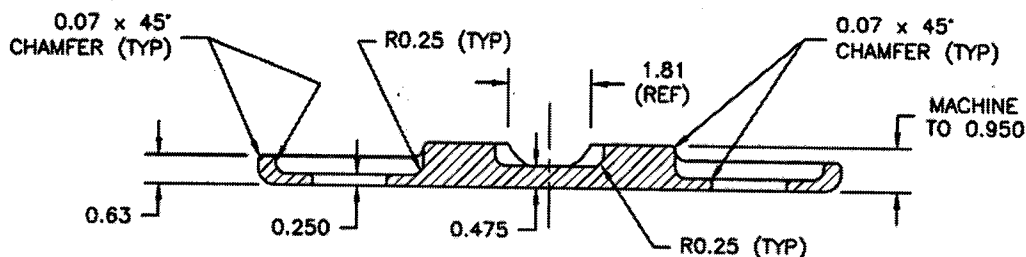
20151210
SH139853

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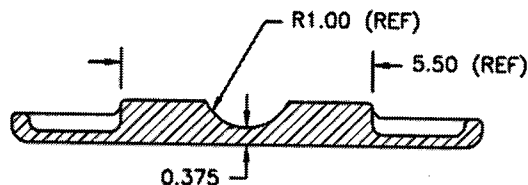
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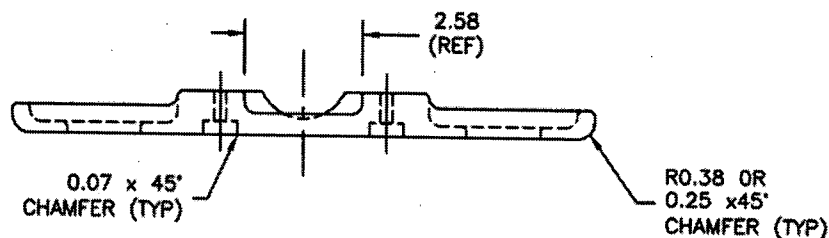
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CHECKED #	APPROVED #	DRAWING NO. D3076	REV. A
DATE 02.01.08		TITLE R22 BEARPAW	SHEET 2 OF 2
			SCALE 1:4



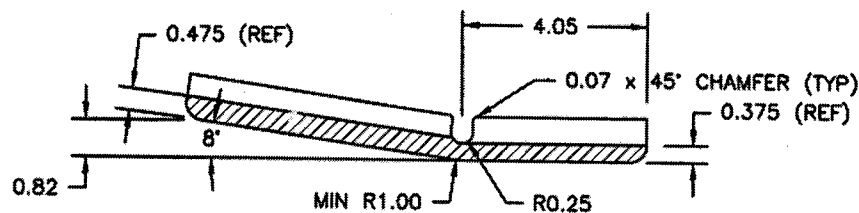
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D (AFTER BENDING)

RELEASED
02.01.10

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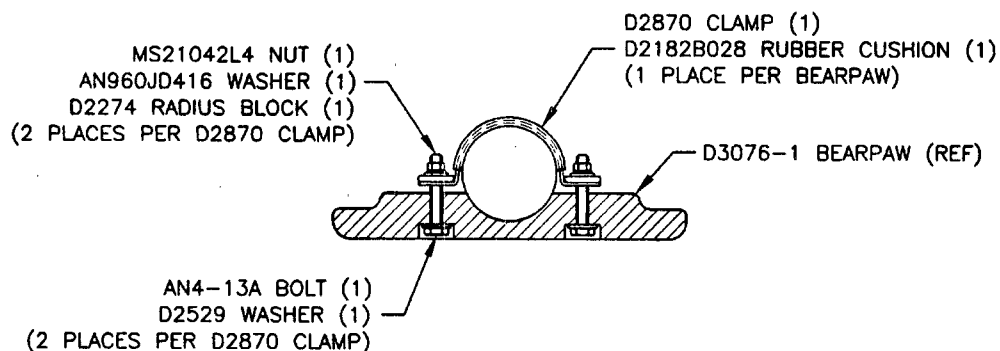


Figure 3 - Bearpaw Installation. Forward Clamp (section view)

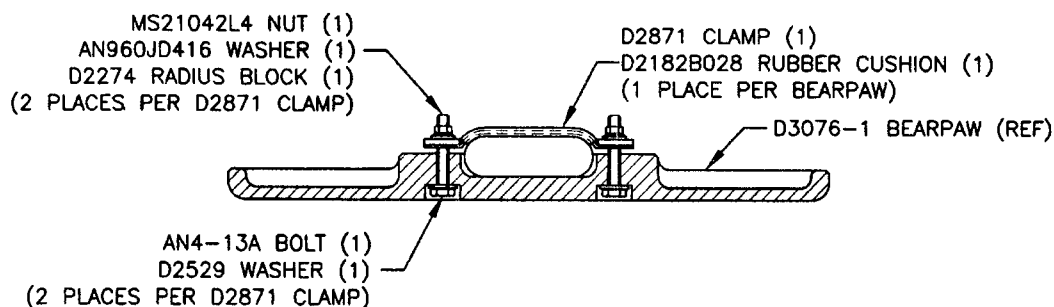


Figure 4 - Bearpaw Installation. Aft Clamp (section view)

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D022-661-011 Bearpaw Installation on model R22 aircraft	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	121.1 in 3.08 m	557.1 in-lb 6.47 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D022-661-011	BEARPAW INSTALLATION
4	D2182B028	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2870	Clamp
2	D2871	Clamp
2	D3076-1	Bearpaw
8	AN4-13A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

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Revision: B

Date: 02.01.03

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REFERENCE ONLY

ICA-D022-661

ICA Page 21 (22 blank) of 22

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D022-661-011 Bearpaw Installation on model R22 aircraft	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	121.1 in 3.08 m	557.1 in-lb 6.47 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D022-661-011	BEARPAW INSTALLATION
4	D2182B028	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2870	Clamp
2	D2871	Clamp
2	D3076-1	Bearpaw
8	AN4-13A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

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32-00-00

Page 5 (6 blank) of 6